

**METHOD FOR PRODUCING A BALL-AND-SOCKET JOINT BETWEEN**  
**A SLIPPER AND A PISTON, AND A BALL-AND-SOCKET JOINT**  
**OF THIS TYPE**

**ABSTRACT**

10 The invention relates to a method for producing a ball-and-socket joint (1) between a  
slipper (3) and a piston (2) of a piston engine, comprising the following steps:  
configuring the slipper (3) with a joint ball (4) at the end opposite the bottom surface  
(21); configuring the piston (2) with an overmeasure (x) on its lateral surface (2c) and  
a hemispherical joint recess (5) with a recess edge (7) that protrudes beyond the  
equator (6) of the joint recess (5), for the joint ball (4) at a front end of the piston (2);  
15 bringing together the joint recess (5) and the joint ball (4); beading the recess edge (7)  
into a form in which it grips the joint ball (4) from behind; and finishing the lateral  
surface (2c) of the piston (2). The following steps are also provided for the purpose of  
simplifying and improving the production process: bringing together the joint recess  
(5) and the joint ball (4) after finishing the lateral surface (2c) of the piston (2); locally  
20 heating the recess edge (7) to a temperature that reduces its hardness; and beading the  
recess edge (7).